

Friday, 9/21/2007 1:19:01 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UPPER AND LOWER PLATE
 Job Number : 34824
 Estimate Number : 12838
 P.O. Number : N/A Part Number : D3524041
 This Issue : 9/21/2007 S.O. No. : N/A Drawing Number : UNDER REVIEW D3524
 Prsht Rev. : NC Project Number : N/A
 First Issue : 9/21/2007 Type : MACHINED PARTS Drawing Revision : N/A AD 07/09/24 EC
 Previous Run : 33303 Material : N/A
 Due Date : 10/12/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 07-04-18 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

10 M6061T6B0375X03000 6061T6 BAR .375 X 3.00



Comment: Qty.: 0.3236 f(s)/Unit Total: 1.6181 f(s)

NO BATCH # IN COMPUTER

6061-T6 Bar .375" X 3.00"

batch: 1105225DIP 07/10/0520

20 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.700 " long

DIP 07/10/0520

30 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA700 Rev. AA & Dwg D3524Rev: A

2-Deburr per dwg D3443

gmk 07/10/0920

40 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

gmk 07/10/0920

50 QC8 SECOND CHECK



Comment: SECOND CHECK

3.2 07/10/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/11	11	Split w/o			SB	07/10/11	17		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: UPPER AND LOWER PLATE

Job Number: 34824

Part Number: D3524041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
C'SINK AS PER DWG D3524

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9.0

MS21075L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

batch: m101502 x 68 mx

mf

10.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

RIVET

batch: m102404 x 136 mx

mf 07-10-11

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
RIVET NUT PLATES AS PER DWG D3524

mf 07-10-11

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/10/11 12x 50

PTO
Front page



Process Sheet

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Drawing Name: UPPER AND LOWER PLATE

Job Number: 34824

Part Number: D3524041

Job Number:



Seq. #:

Machine Or Operation:

Description :

140

QC21

FINAL INSPECTION/W/O RELEASE



(17)

Comment: FINAL INSPECTION/W/O RELEASE

207/10/10

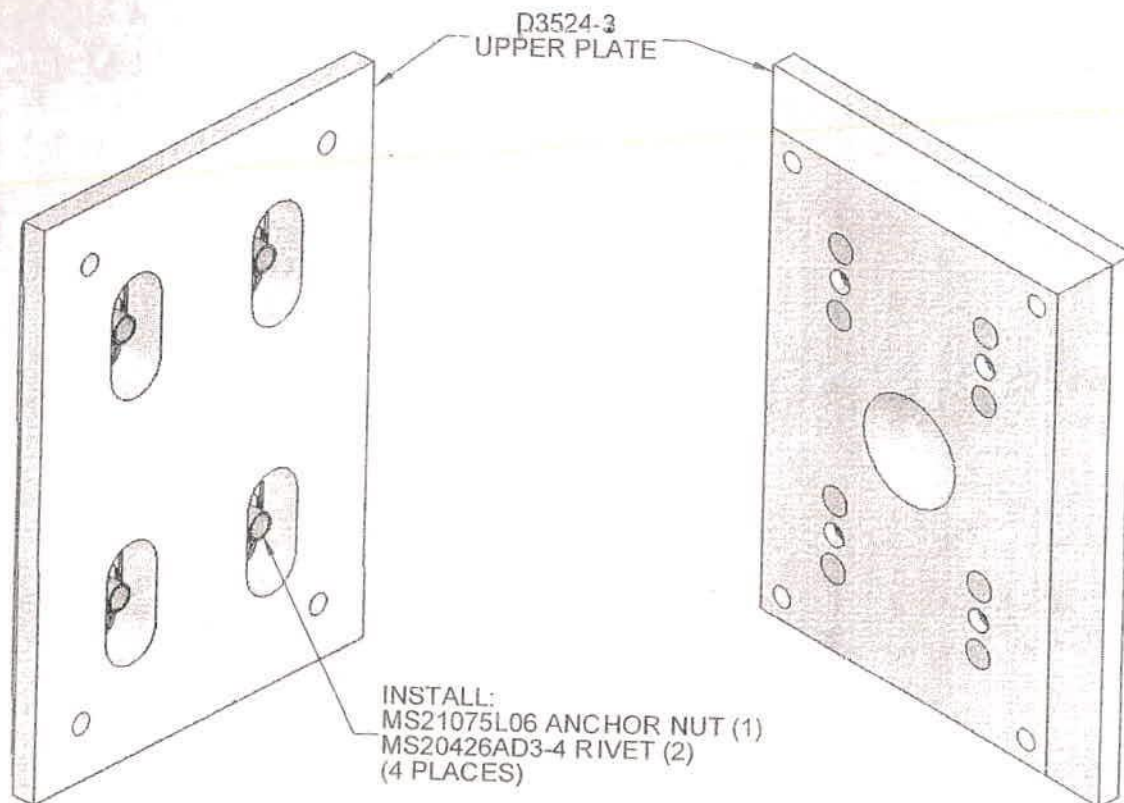
Job Completion:



W 10/10/10



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3524	REV. A
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SHEET 2 OF 3 SCALE 1:1



D3524-041 UPPER PLATE ASSEMBLY

RELEASED
27-03-03

PARTS LIST:

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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WORK ORDER

NO. _____

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